Date:

Friday, 1/6/2006 12:57:42 PM

Linda Lacelle User: **Process Sheet Drawing Name** Customer : CU-DAR001 Dart Helicopters Services : SPACER **Job Number** : 25402 : 11497 **Estimate Number** : D31943 **Part Number** P.O. Number : 1/6/2006 S.O. No. : **Drawing Number** : D3194 REV A This Issue : N/A : NC **Project Number** Prsht Rev. : SMALL /MED FAB : A First Issue Type **Drawing Revision** Material **Previous Run** : 1/13/2006 Qty: 100 Um: Each **Due Date** Written By **Checked & Approved By** Comment Est: Α 03.06.18 New issue KJ/RF **Additional Product** Job Number: Description: Machine Or Operation: Seq. #: **PURCHASING** 1.0 **Comment: PURCHASING** Note: 31 x 48 sheet makes Qty (240) D3194-1. Dwg not required Issue P/O: Material: Black Delrin II 150E 30" x48" x 0.125" thick sheet Material release note required 2.0 D31943 Spacer Comment: Qty.: 1.0000 Each(s)/Unit Total: 100.0000 Each(s) Spacer PACKAGING RESOURCE #1 3.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Recieive & Inspect for Transit Damage Ensure Material Release Note is attached MDELRINS0125X300 4.0 Black Delrin Comment: Qty.: 3.4230 sf(s)0.0342 sf(s)/Unit Total:

Black Delrin

Material: Black Delrin/UHMW 0.125" thick

(M-Delrin-S0.125x30.000)

Batch:

Dart Ae	rospace L	td							
W/O:			V	ORK ORDER CHANGES					
DATE STEP		PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cat	tegory: NC	R: Yes	No DQ	A :	_ Date: _	
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Date:

Friday, 1/6/2006 12:57:42 PM

User:

Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 25402

Part Number: D31943

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

SHEAR

SHEAR



Comment: SHEAR

Cut blanks: 20 strips at 2.19" x 30.0" long. Use DT8685 Router Table to cut strips. Shear 30" parts into 3 x 10" lengths.

6.0

HAAS1

HAAS CNC VERTICAL MACHINING #1 .



Comment: HAAS CNC VERTICAL MACHINING #1

Machine per Folio FA244 and Dwg D3194 to make Qty (4) parts per 10" length.

Deburr

7.0

INSPECT PARTS AS THEY COME OFF MACHINE





Comment: INSPECT PARTS AS THEY COME OFF MACHINE

8.0

QC8

QC2

SECOND CHECK



Comment: SECOND CHECK

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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	WORK ORDER NON-CONFORMANCE (NCR)								
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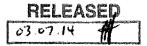
NOTE: Date & initial all entries

QA: N/C Closed: ____ Date: ____

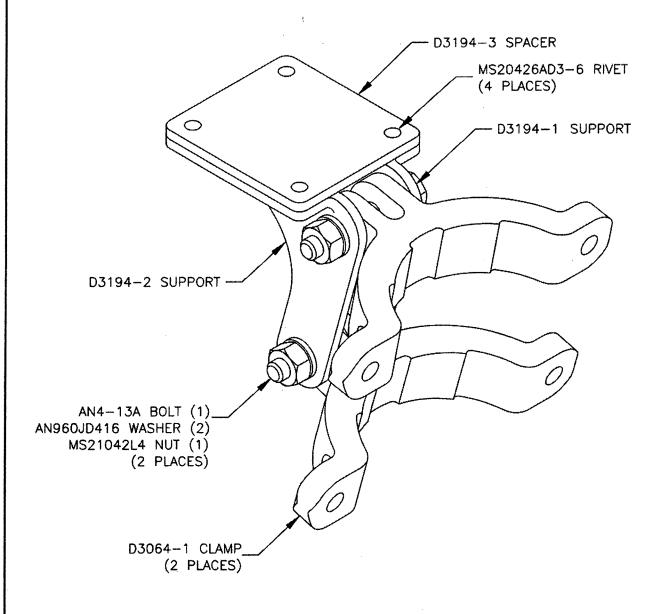




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		AN	9	D3194	SHEET 1 OF 3
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T	Α		03.06.12	NEW ISSUE	



D3194-041 SUPPORT ASSEMBLY



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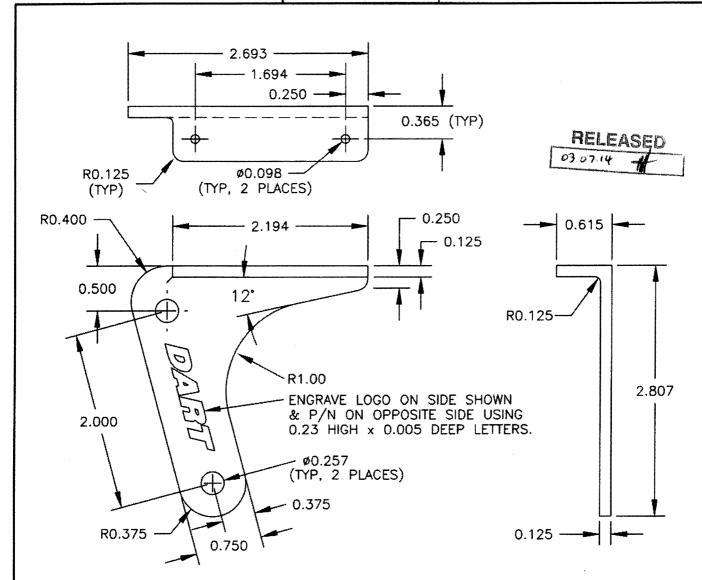
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1	#	TR	D3194	SHEET 2 OF 3
-	DATE		TITLE	SCALE
	03.06.12		SUPPORT	1:1



D3194-1 SUPPORT (SHOWN)

D3194-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3194-1.SLDPRT"
- 2) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/8 OR QQ-A-250/11) (REF_DART_SPEC. M6061T6B OR M6061T6S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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W/O:		WORK ORDER CHANGES									
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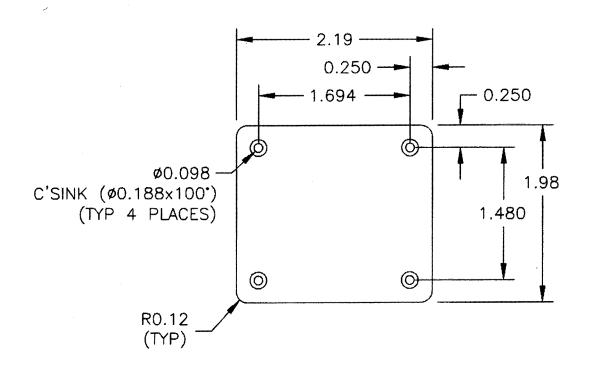
NCR: WORK ORDER NON-CONFORMANCE (NCR)								
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03.06.12	2		SUPPORT	1:1

RELEASE 63.07.14



D3194-3 SPACER

- 1) MATERIAL: BLACK DELRIN / UHMW PER DART SPEC M-DELRIN-B OR M-DELRIN-S 0.125 THICK
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE IN INCHES.

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification	Annroyal	Approval
			Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
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